

Work Order ID 57817

April 16, 2010 10:34:39 AM



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Item ID: D3908-5

Accept



Setup Start



Revision ID:

Item Name: Eyebolt Stud

Stop



Start Date: 16/04/2010 Start Qty: 6.00

Required Date: 29/04/2010 Req'd Qty: 6.00

Reference: *29/10.04.26.*

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3908

B

100

0.00



Doosan

Memo

0.00

Doosan Lathe

turn as per dwg and folio FA922

DWG REV: B
FOLIO REV: N/A

SL 10/04/17

6

Ø

DEBURR

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SL 10/04/17

6

Ø

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Start Date: 16/04/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

DTJ
10/04/17

6 *0*

150

Identify as per dwg & Stock Location: *CG8* *Pass Q* 0.00



Packaging

Memo

0.00

Packaging

PC 10/4/20 *(6)*

160

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

10/04/20 *MF*
10-4-20

Picklist Print

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Work Order ID: 57817

Parent Item: D3908-5

Parent Item Name: Eyebolt Stud

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD

Start Date: 16/04/2010

Required Date: 29/04/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M303R1.000

Purchased

No

100

f

45.2000

1.2632



303 Round Bar 1.00

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT028

113325

45.2

45.2

1.3 JL 10/04/17

DART AEROSPACE LTD		Work Order: 57817
Description: eyebolt stud		Part Number: 13908-5
Inspection Dwg: 13908 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.129	+ .005 - .001	.129	✓			
.750	+ .010 - .010	.750	✓			
.375 (pitch)	+ .010 - .010	.375	✓			
.310	+ .010 - .010	.312	✓			
.350	+ .010 - .010	.348	✓			
.230 X 45°	+ .010 + .5° - 0	.230 X 45°	✓			
.700	+ .010 - .000	.696	✓			
Ø.266	+ .000 - .001	.267	✓			
5.060	+ .010 - .010	5.060	✓			
.70	+ .030 - .030	.701	✓			
1.38	+ .030 - .030	1.380	✓			
1.00	+ .030 - .010	.999	✓			
.735 +	+ 0 - 0	.741	✓			
.75	+ .030 - .030	.751	✓			

Measured by: JL	Audited by: JIP	Prototype Approval:	N/A
Date: 10/04/17	Date: 10/04/17	Date:	N/A

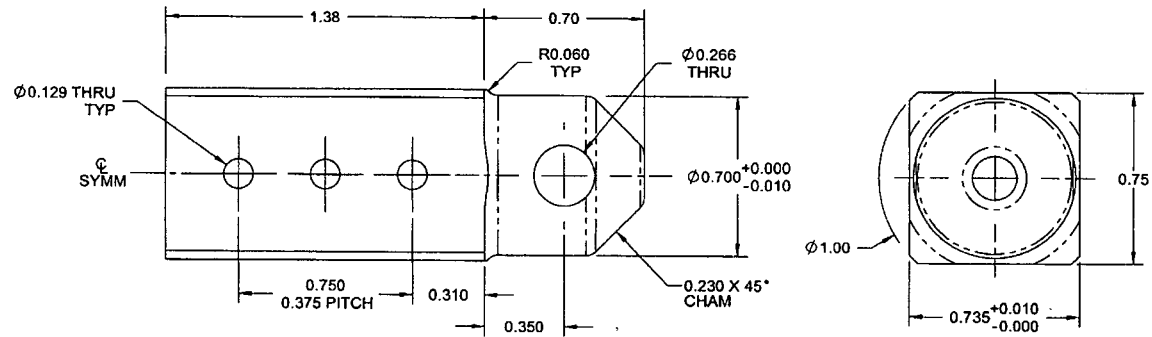
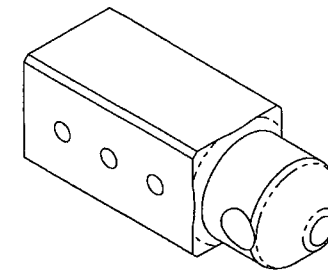
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



The value adding parts of the process are obvious, so companies mistakenly focus on trying to make them go faster. The waste is not obvious, so it is not addressed. Lean focuses on eliminating the waste.

Lean is ongoing, there is no end to the search for waste!

W/0 57817



D3908-5 EYEBOLT STUD



RELEASED
2010-04-14
MD

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582 PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. D3908	REV. B
MFG. APPR.	JPH	TITLE X-TUBE LUG ASSY (AFT)	SCALE NTS
APPROVED	JPH	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.	JPH		
DATE	10.04.06		